

Date: Thursday, 3/13/2008 10:19:28 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001~Dart Helicopters Services	Drawing Name : STEP LEG
Job Number : 37925A	
Estimate Number : 10353	
P.O. Number :	Part Number : D2278
This Issue : 3/13/2008 S.O. No. :	Drawing Number : D2278 REV F
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : F
Previous Run : 37452A	Material :
Written By :	Due Date : 3/28/2008 Qty: 20 Um: Each
Checked & Approved By : <u>1080313</u>	
Comment : Est Rev:A New Issue 05-11-07 JLM	
Est Rev:B Now 6061-T6 06-06-23 JLM	
Est Rev C New flat pattern 08.01.11 EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S080,	6061-T6 .080 Sheet
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MAT NOT PULLED



Comment: Qty.: 1.0306 sf(s)/Unit Total : 20.6115 sf(s)  
 Material: 6061-T6 sheet (QQ-A-250/8) 0.080" Thick  
 (M6061T6S.080)  
 Identify as D2278  
 Batch: 10746 1B 8-3-26

MAT USED 2024

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
 1-Cut as per Dwg D2278  
 Dwg Rev: F  
 Prog Rev: F

1B 8-3-26

(21)

2-Deburr if necessary 1B 8-3-26

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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1B 8-3-26



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

08/03/26 (421) counters

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2278 PAR #: NA Fault Category: Prod / PB 155 <sup>mod of Small</sup> NCR: Yes No DQA: D Date: 22/03/27  
 QA: N/C Closed: D Date: 08/03/29

NCR: 37925A		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06.03.27	1.0	MAT'L IS 2024-T3 INSTEAD OF 6061-T6.	<div>Initial Chief Eng</div> <div>06.03.27</div>	2024-T3 IS STRONGER THAN 6061-T6. ACCEPTABLE DEVIATION PER Q51 012.	<div>Sign &amp; Date</div> <div>HB 06.03.27</div>	<div>Verification Section C</div> <div>06/03/28</div>	<div>Approval Chief Eng</div> <div>06.03.27</div>	<div>Approval QC Inspector</div> <div>06/03/28</div>

NOTE: Date & initial all entries

Date: Thursday, 3/13/2008 10:19:28 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP LEG

Job Number: 37925A

Part Number: D2278

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(21)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BR 08-03-26

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(21X)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-A 08/02/26

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: C-A

SB 08'03/26 21

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(21)

Comment: FINAL INSPECTION/W/O RELEASE

08/03/27

Job Completion



MF

08-03-27

(21)

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 37925 A
<b>Description: Leg</b>		<b>Part Number:</b> D2278
<b>Inspection Dwg: D2278      Rev: F</b>		<b>Page 1 of 1</b>

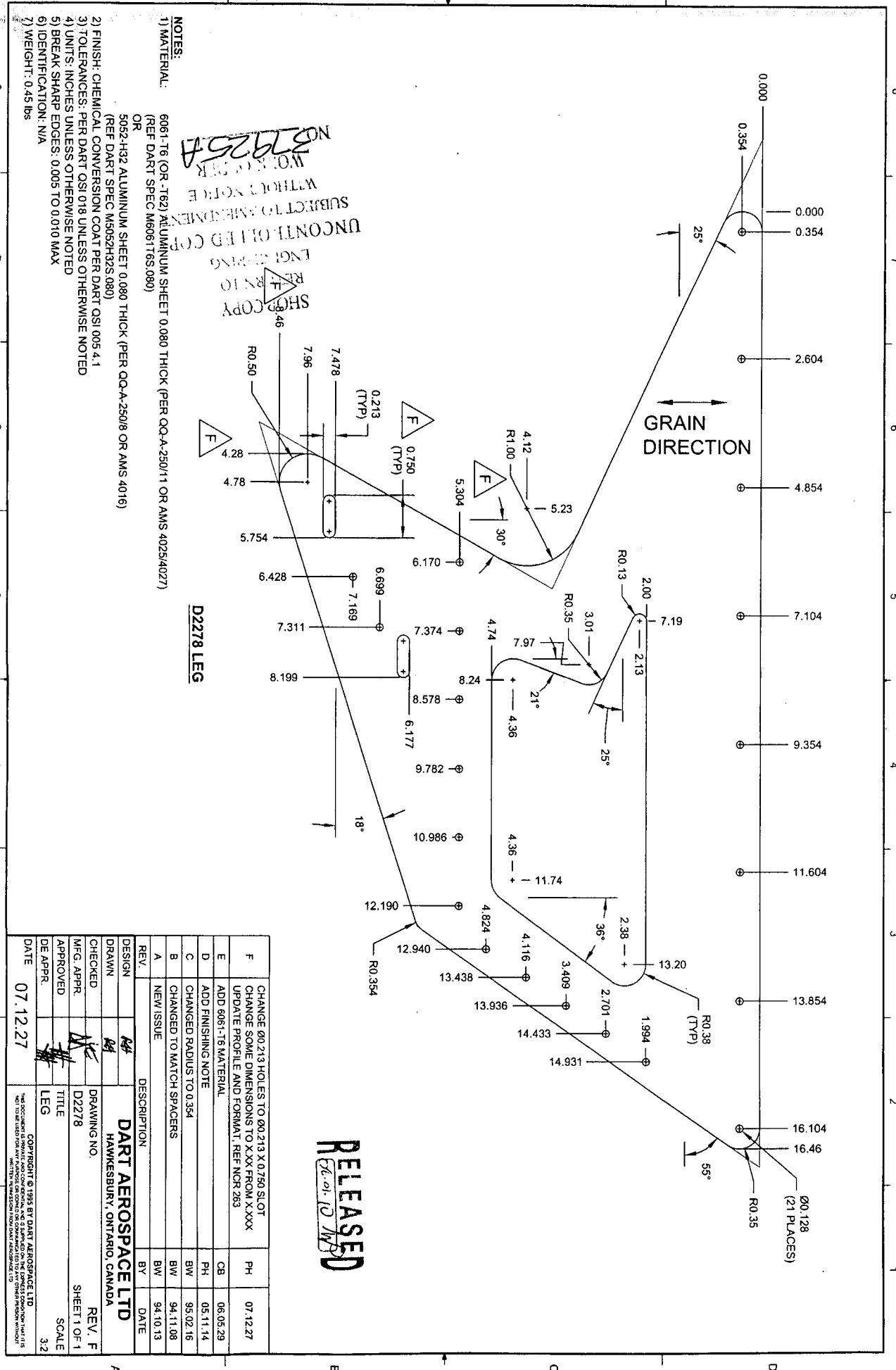
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.354	+/-0.010	0.354	*			
0.354	+/-0.010	0.354	*			
16.46	+/-0.030	16.46	*			
Ø0.128	+0.005/-0.000	0.128	*			
R0.354	+/-0.030	0.354	*			
2.00	+/-0.030	2.01	*			
4.74	+/-0.030	4.744	*			
8.46	+/-0.030	8.46	*			
0.213	+/-0.010	0.213	*			
0.750	+/-0.010	0.749	*			
0.080 thick	+/-0.010	0.080	*			

<b>Measured by:</b> RB	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 8-3-20	<b>Date:</b> 08/03/06	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.10.12	New Issue P/O D2582	KJ/JLM	
B	06.03.08	Dwg Rev. changed	KJ/JLM	
C	06.06.23	Dwg Rev. changed	KJ/JLM	
D	08.02.28	Dimensions updated per Dwg Rev F	KJ/DD [Signature]	[Signature]



NOTES:  
1) MATERIAL: 6061-T6 (OR -T62) ALUMINUM SHEET 0.080 THICK (PER QQ-A-250/11 OR AMS 4025/4027)  
(REF DART SPEC M6061T6S 080)  
OR  
5052-H32 ALUMINUM SHEET 0.080 THICK (PER QQ-A-250/8 OR AMS 4016)  
(REF DART SPEC M5052H32S 080)  
2) FINISH: CHEMICAL CONVERSION COAT PER DART OSI 005.4.1  
3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT: 0.45 lbs

REV.	DESCRIPTION	DATE
F	CHANGE Ø0.213 HOLES TO Ø0.213 X 0.750 S.LOT CHANGE SOME DIMENSIONS TO X.XX FROM X.XXX UPDATE PROFILE AND FORMAT. REF NCR 263	07.12.27
E	ADD 6061-T6 MATERIAL	06.05.29
D	ADD FINISHING NOTE	05.11.14
C	CHANGED RADIUS TO 0.354	05.02.16
B	CHANGED TO MATCH SPACERS	04.11.08
A	NEW ISSUE	04.10.13
DESIGN	DART AEROSPACE LTD	
DRAWN	HAWKESBURY, ONTARIO, CANADA	
CHECKED		
MFG. APPR.	D2278	REV. F
APPROVED		SHEET 1 OF 1
DE APPR.		SCALE
DATE	07.12.27	3.2

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RELEASED  
26.01.10 JWP